

Date: Monday, 1/14/2008 2:29:06 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ARM		
Job Number	: 36715					
Estimate Number	: 10145					
P.O. Number	:			Part Number	: D2037101	
This Issue	: 1/14/2008		S.O. No. :	Drawing Number	: D2037 REV C3	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: C3	
Previous Run	: 36507			Material	:	
Written By	:			Due Date	: 1/31/2008	
Checked & Approved By	: <u>10 08.01.15</u>			Qty:	5 Um: Each	
Comment	: Est Rev:A New Issue 05-11-01 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0750W049	304 RD Tube .750 x .049W	
		Comment: Qty.: 4.1118 f(s)/Unit Total : 20.5590 f(s) Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless tubing (M304TR0.750W.049) Batch: <u>M107098</u>	<u>SP 08/02/12</u>
2.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE	<u>SP 08/02/12</u>
		1-Punch as per Dwg D2037. Keep hole distance 45.50" using Jig D2037-101T1	<u>SP 08/02/12</u>
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	<u>SP 08/02/12</u>
		1-Drill Ø0.323" holes in D2037-101 tube as per Dwg D2037	<u>SP 08/02/12</u>
		2-Flatten ends of D2037-101 tube as required using DT8545	<u>SP 08/02/12</u>
		3-Deburr as required	<u>SP 08/02/12</u>
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	<u>SP 08/02/12</u>
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1	<u>SP 08/02/12</u>
		Identify and Stock	<u>SP 08/02/12</u>
		Location: <u>W/1241A</u>	<u>SP 08/02/12</u>

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/02/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 36715

Part Number: D2037101

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

1/14/2008

Job Completion



ini 2008/1/20

(5)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

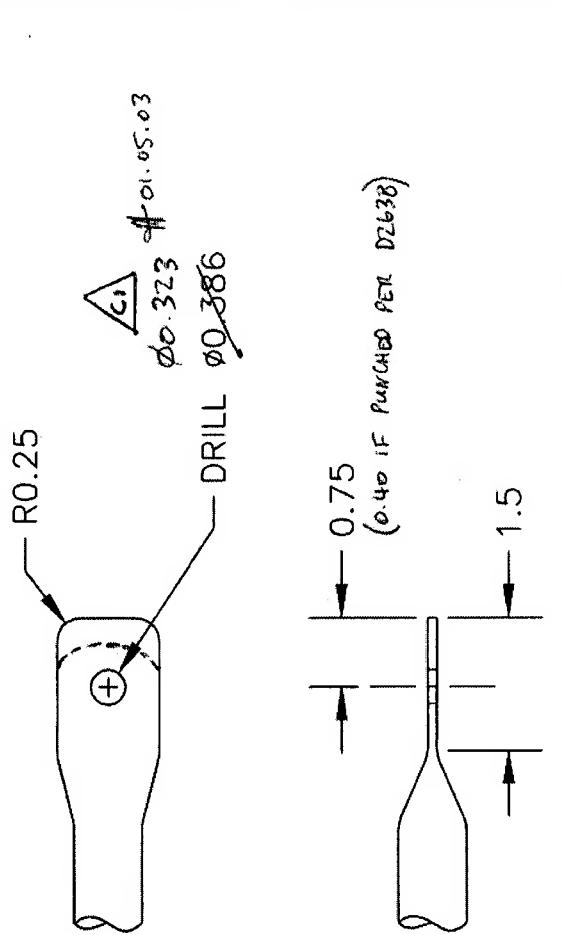
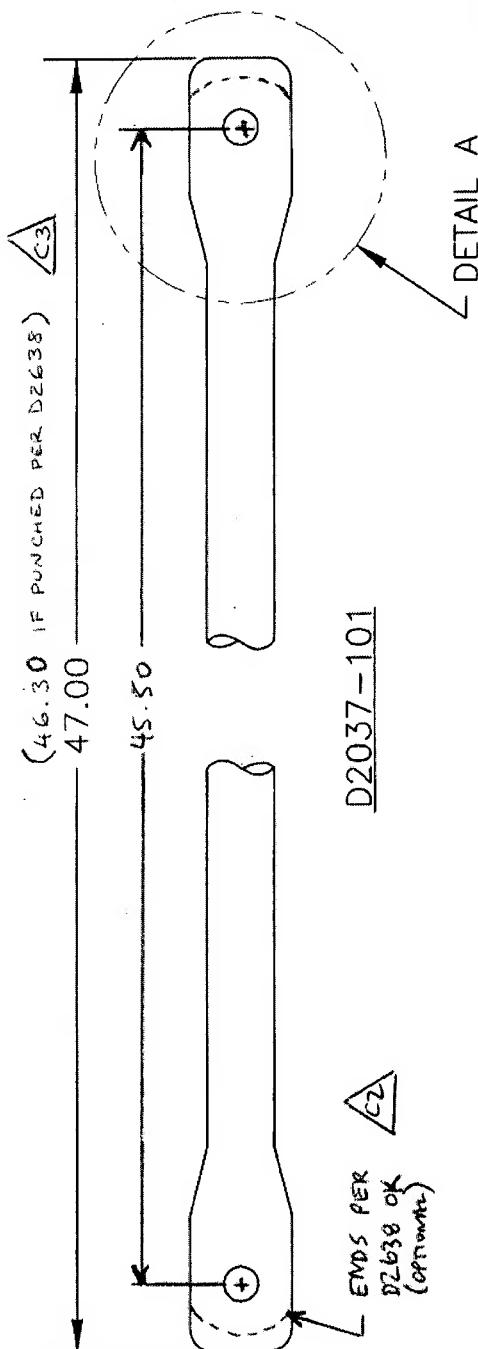
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DARTD COPY IS
Done

DESIGN JB	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED J	DRAWING NO. D2037
DATE 99.06.07	TITLE ARM	REV. C SHEET 1 OF 1
		SCALE NTS
A	91.10.22	NEW ISSUE
B	93.04.20	-103 DELETED
C	99.06.07	REDRAWN, 0.386 WAS 0.375
C1	if 01.05.03	CHANGE TO ϕ 0.323
C2	if 02.06.14	ADD PUNCH PER D2638 As option



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36715

MATERIAL: AISI 304/316 SS SEAMLESS TUBE, 0.750 O.D. x 0.049 WALL

C3	if 05.04.27	ADD 46.30 PUNCHED PER D2638
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